

**Work Order ID 64570**

Page 1

Wednesday, December 08, 2010 10:27:59 A

Item ID: D3805-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 12/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 10/28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3805

Rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3805

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B 10-12-17

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64570**

Wednesday, December 08, 2010 10:27:59 A

Page 2

Item ID: D3805-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 12/8/2010 Start Qty: 6.00

Required Date: 12/22/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Wednesday, December 08, 2010 10:27:59 A

Page 3

Item ID: D3805-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 12/8/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

EL 11-5-10 (X6)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11  
mf  
11-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 08, 2010 10:28:03 AM

Page 1

Work Order ID: 64570

Parent Item: D3805-5

Parent Item Name: Plate




Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	122.6200	1.587	10.02316			



12-10-12-17

Location	Loc Qty	Loc Code
MAT	96	
116135	96	
MAT20	26.62	
111743	4.75	
113062	20.77	
115389	1.1	

116 135

(6)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	04570
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3805-5
<b>Inspection Dwg:</b> D3805 <b>Rev:</b> A			<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

**x**

## First Article

.....



## Prototype

[illegible]

Measured by:	IB
Date:	10-12-17

Audited by:	S
Date:	10/12/20

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

8

7

6

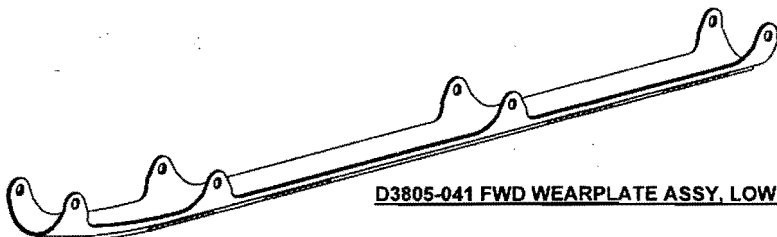
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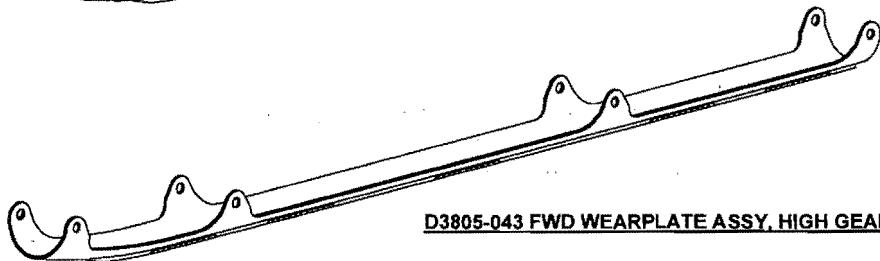
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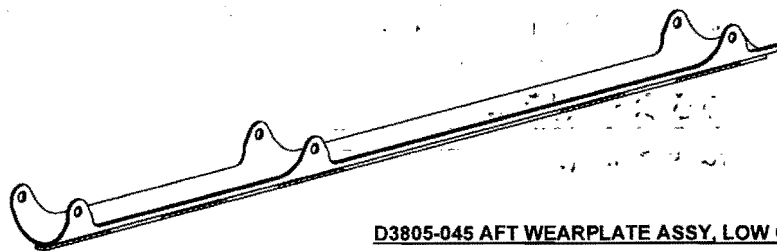
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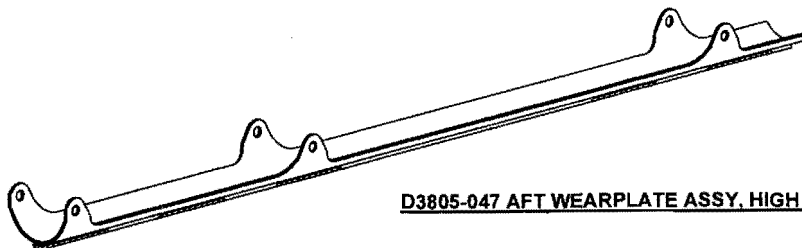
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44370  
B11012-1

RELEASED  
UP 09.03.03  
P4 ECN 09-538

A	NEW ISSUE		MB	08.11.21
REV.		DESCRIPTION	BY	DATE
DESIGN	JP	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN	JS			
CHECKED	JS		DRAWING NO.	REV.
MFG. APPR.	JS		D3805	SHEET 1 OF 8
APPROVED	JS		TITLE	SCALE
DE APPR.	JS		<b>WEARPLATE ASSY</b>	NTS
DATE	08.11.21		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

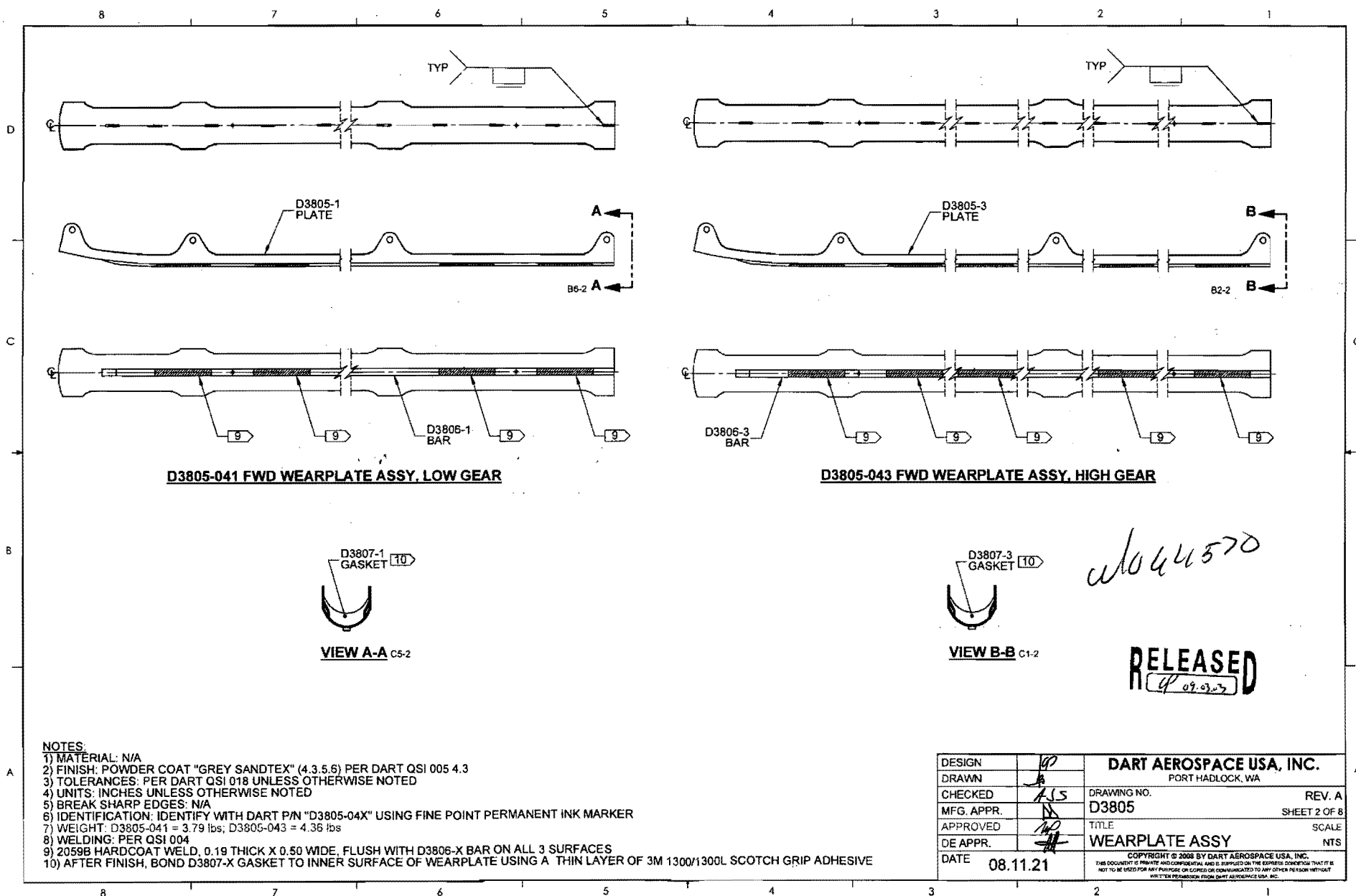
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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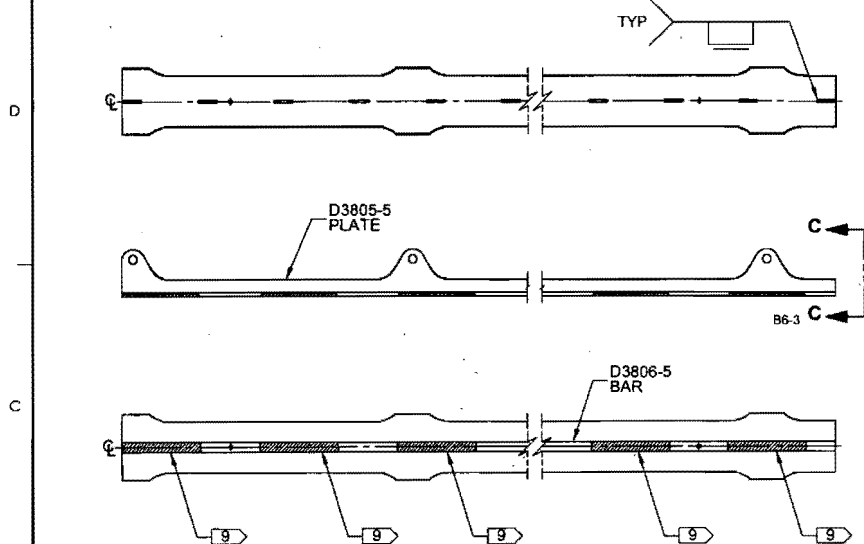
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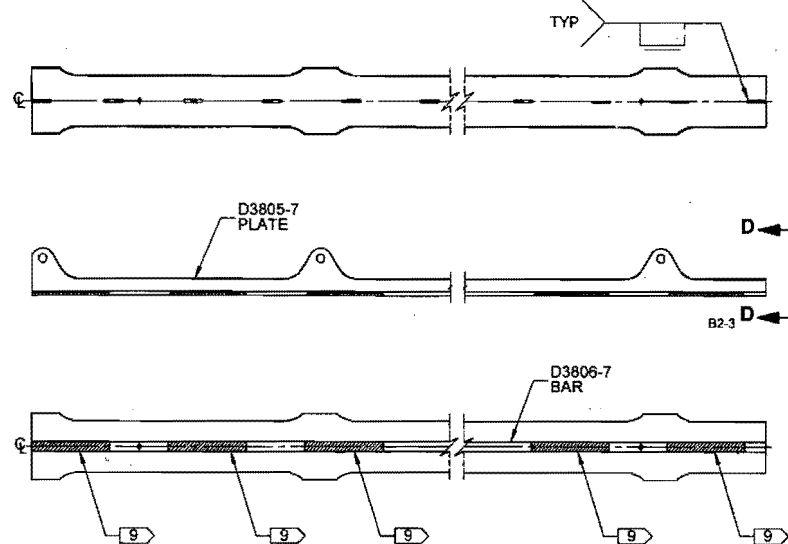
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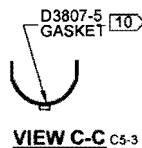
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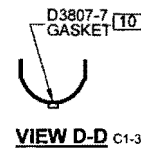
**D3805-045 AFT WEARPLATE ASSY.**



**D3805-047 AFT WEARPLATE ASSY.**



**VIEW C-C C5-3**



**VIEW D-D C1-3**

W10644570

**RELEASED**  
09.03.07

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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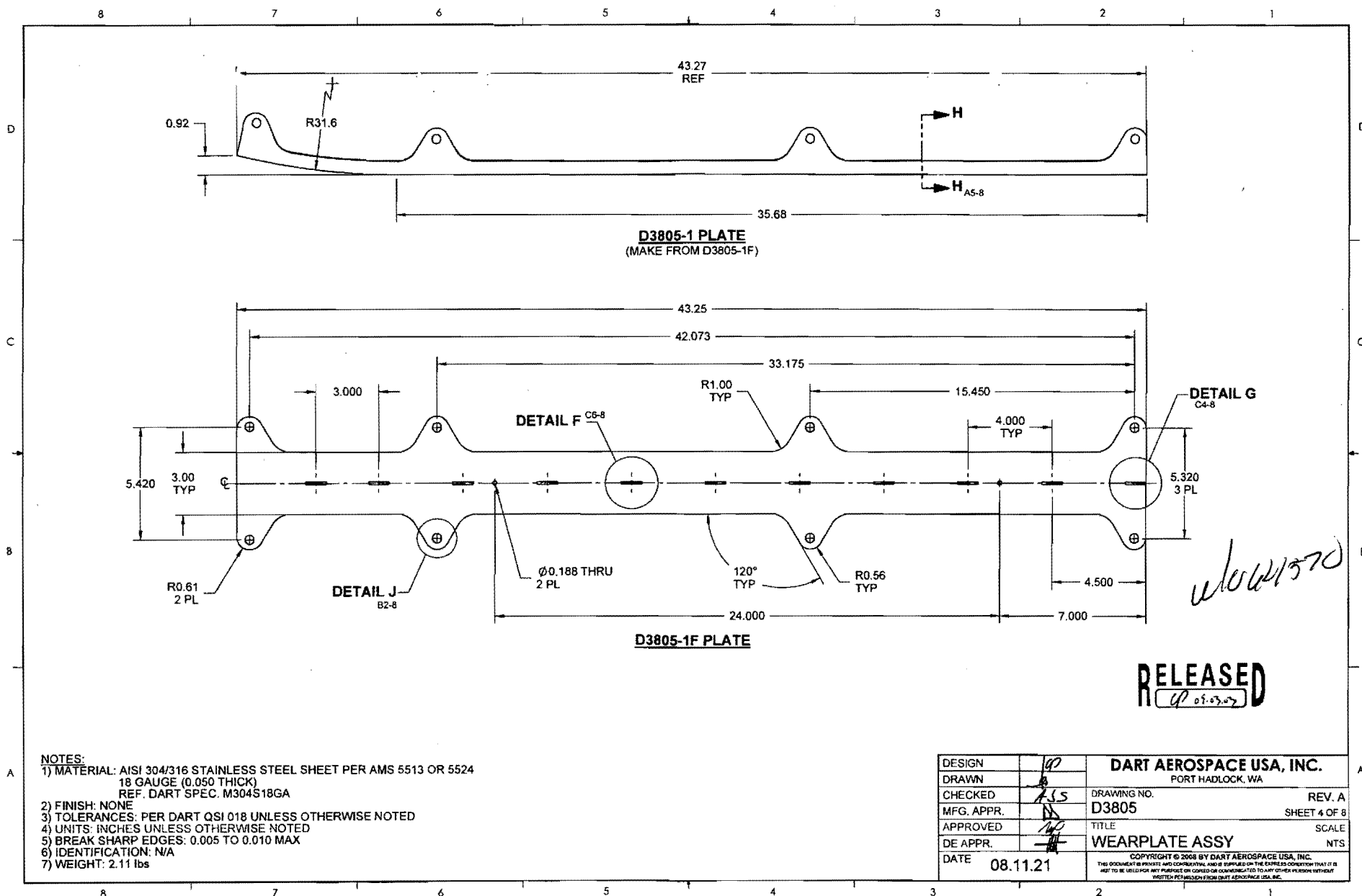
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**NOTE:** Date & initial all entries





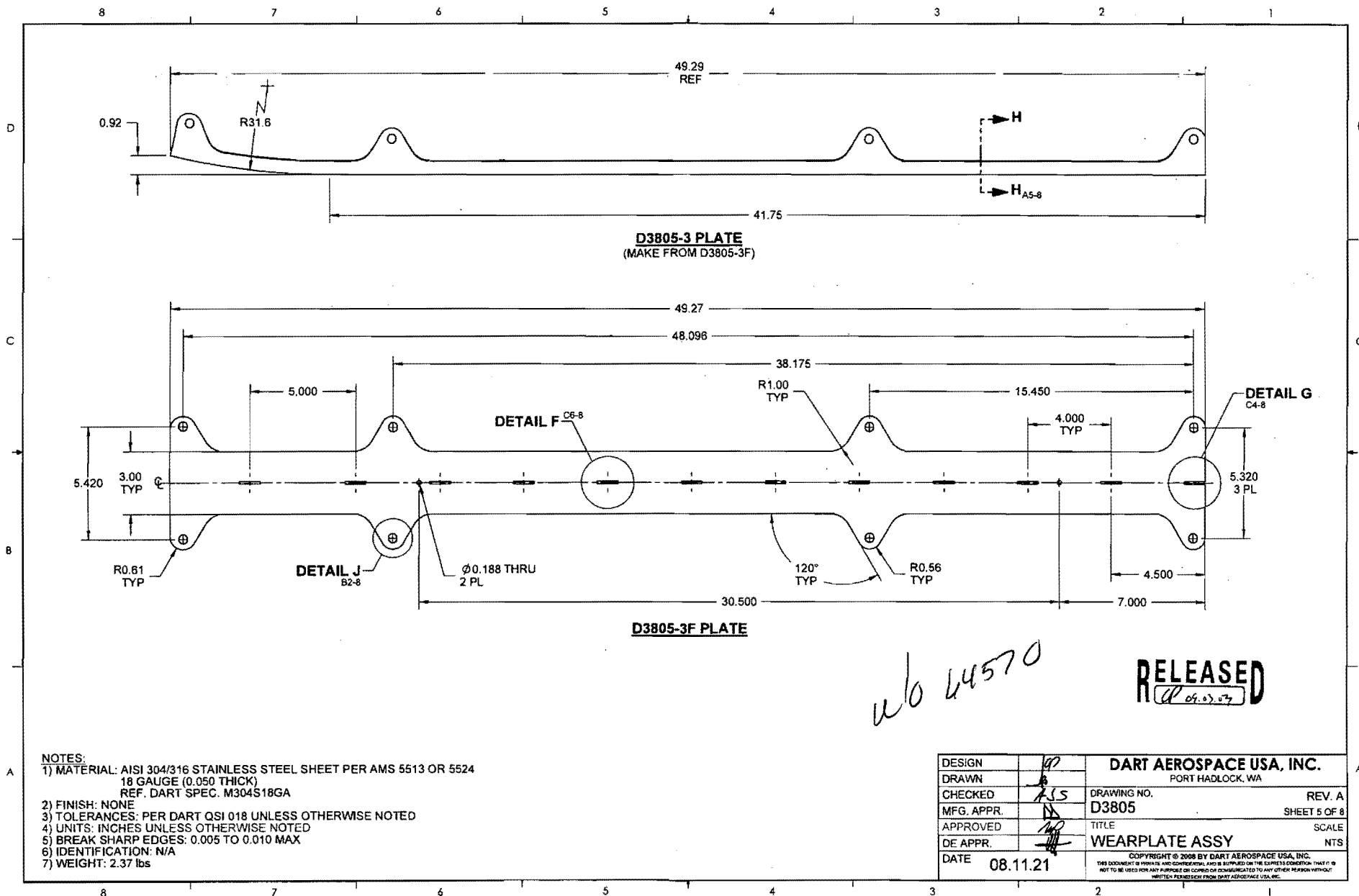
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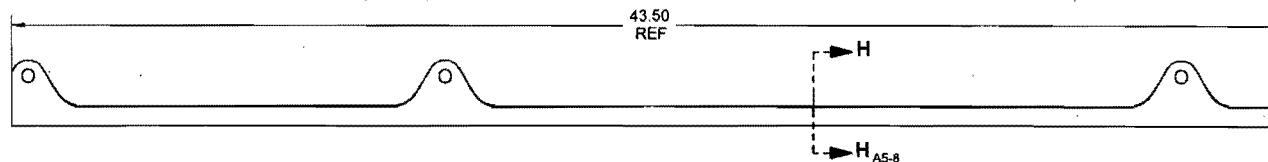
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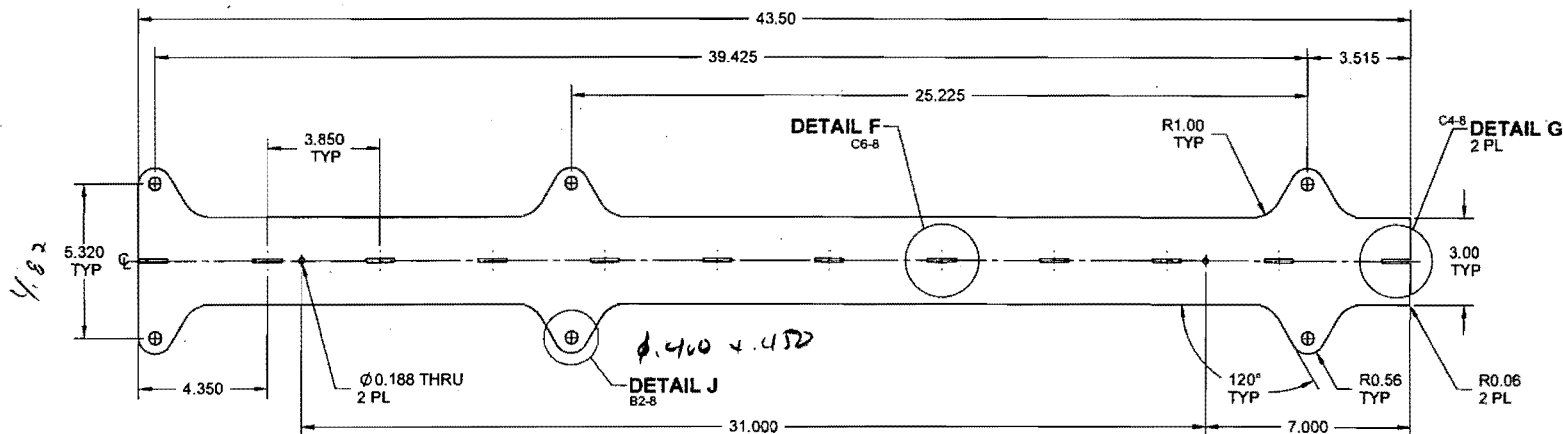
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D3805-5 PLATE**  
(MAKE FROM D3805-5F)



**D3805-5F PLATE**

*u/044570*

**RELEASED**  
49 04 03 03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	<i>49</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>49</i>	PORT HADLOCK, VA	
CHECKED	<i>49</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>49</i>	<b>D3805</b>	SHEET 6 OF 8
APPROVED	<i>49</i>	TITLE	SCALE
DE APPR.	<i>49</i>	<b>WEARPLATE ASSY</b>	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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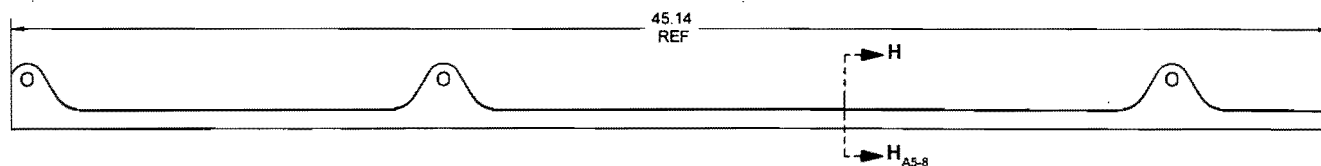
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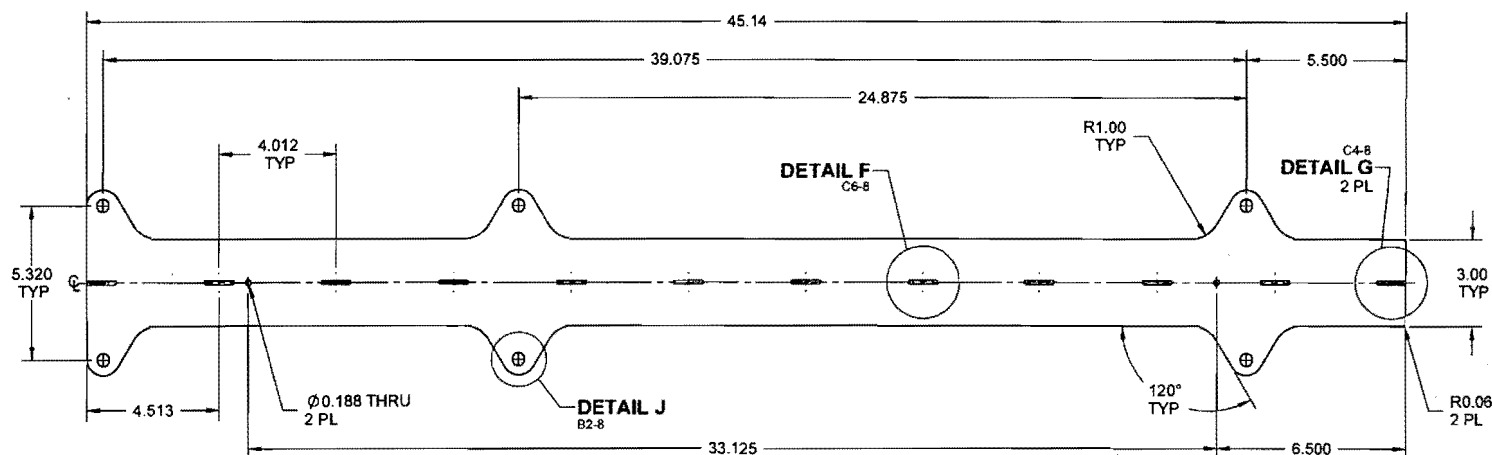
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8 7 6 5 4 3 2 1



**D3805-7 PLATE**  
(MAKE FROM D3805-7F)



**D3805-7F PLATE**

*w/o 64570*

**RELEASED**  
*GP 04.03.07*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	<i>GP</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>AS</i>	PORT HADLOCK, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	<b>D3805</b>	SHEET 7 OF 8
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	<b>WEARPLATE ASSY</b>	NTS
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8 7 6 5 4 3 2 1

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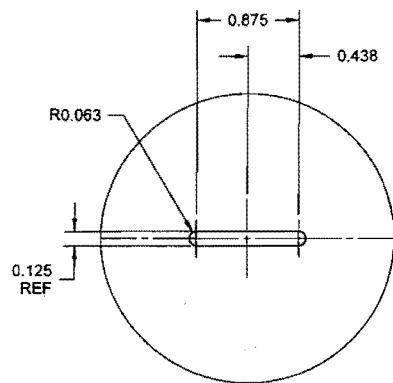
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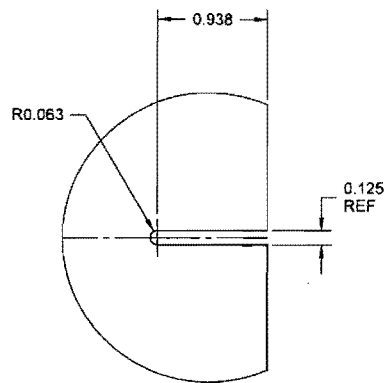
**NOTE:** Date & initial all entries





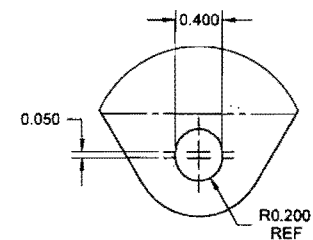
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C3-4  
C3-5  
C3-6  
C3-7



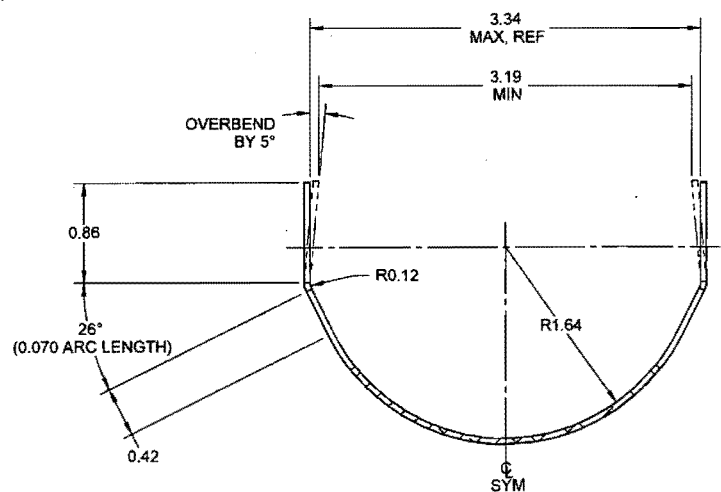
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

DESIGN	197	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO. D3805	REV. A
MFG. APPR.	AS	SHEET 8 OF 8	
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u/b 64570

**RELEASED**  
4709.03.03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries